

Work Order ID 149656***149656***

Page 1

Tuesday, July 26, 2016 10:22:23 AM

Item ID: D4930-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 7/15/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 27 2016

Tooling:

Date:

Run Start ***NR1***QC: 9-89 Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4930	B

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.06

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4930-3 BLANK

(4) + 1

2c 16/08/29
2c 16/09/24

120

0.43

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.15

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FB218 and Dwg

FOLIO REV: BDWG REV: B

3-Deburr

4

1

DAS 44
9-89 16-09-24PTO
→

DQA: SWT Date: 2016-10-7
 QA Closed: RA Date: SEP 30 2015



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>149656</u> Part No. <u>D4930-3</u> NCR No. <u>16-6064</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16-09-24</u>		Step #: <u>120</u>		QTY Effective: <u>1</u>		MRB (QSI042) Approval DAS 9 9-89 <u>16-09-26</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
The corners of the part lifted parts out of tolerance on the cap corners and vibration mark was found on corner P.C. part not place on the right side when machining.				Scrap and replace qty <u>(1x)</u> Batch # <u>135013</u>																																																																			
				Completed By DAS 44 9-89 <u>16-09-24</u> Lead hand / Supervisor Approval Verification DAS 08 9-89 <u>16/09/26</u> QC / QA Coordinator Approval DAS 9 9-89 <u>16-09-26</u>																																																																			
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OTHER :																																																																							

Work Order ID 149656

Tuesday, July 26, 2016 10:22:23 AM

149656

Page 2

Item ID: D4930-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 7/15/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.01

Quality Control

4

1

DAS

44

9-89

16-09-24

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.01

Quality Control

4

0

DAS

20

9-89

16-09-26

150

Identify as per dwg & Stock Location: ST

0.00

150

Packaging

Memo

0.01

Packaging

✓

SEP 27 2016

DAS

6

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 149656

Tuesday, July 26, 2016 10:22:23 AM

149656

Page 3

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Accept

N900040100Setup Start ***NS1***

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Item Name: Bearpaw

Start Date: 7/15/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.07

Quality Control

DAS
21
9-89

SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Tuesday, July 26, 2016 10:22:23 AM

Page 1

Work Order ID: 149656

149656

Parent Item: D4930-3

D4930-3

Parent Item Name: Bearpaw

Start Date: 7/15/2016

Required Date: 7/25/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-10-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	424.7600		7.578947			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

on 16/08/29

Location

Loc Qty

Loc Code

MAT018

424.76

m134823

83.5

m135013

341.26

9 + 2.5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



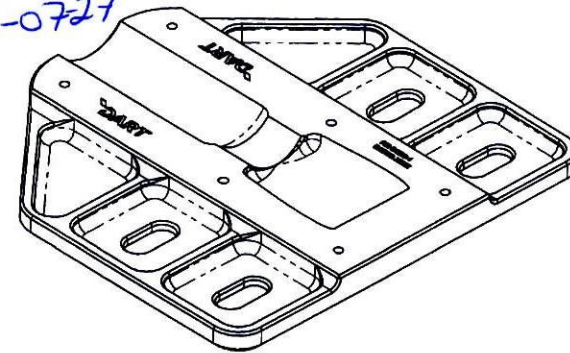
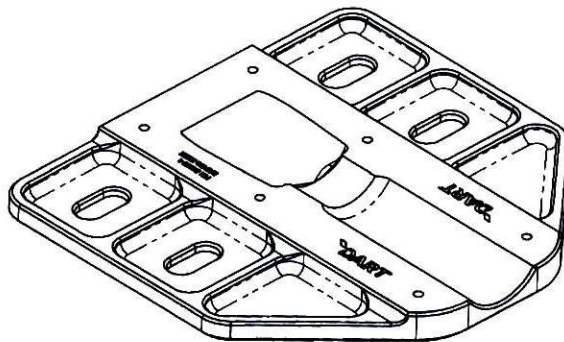
QA Closed: _____ Date: _____

Work Order update only ☐

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 149656 MJS
16-0727

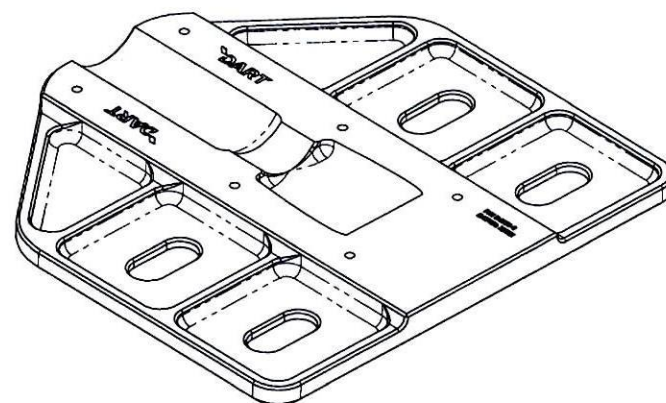
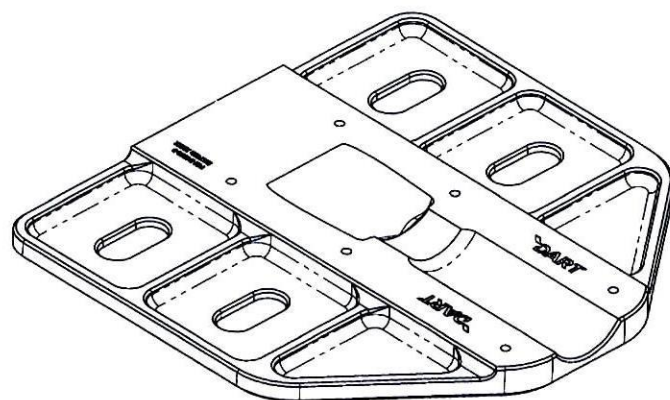


D4930-1 BEARPAW

RELEASED
2013-12-12

B	MOVE CLAMP HOLES 0.250" APART, ZN B2-3, B2-5, ADJUST TANGENT POINT, ZN C7-3, ADJUST RADIUS, ZN C8-3, B5-3, MOVE CLAMP HOLES AFT, ZN B1-3	VS	13.12.05
A	NEW ISSUE	VS	13.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	HS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	13.12.10		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4930 BEARPAW REV. B SHEET 1 OF 6 SCALE NTS			
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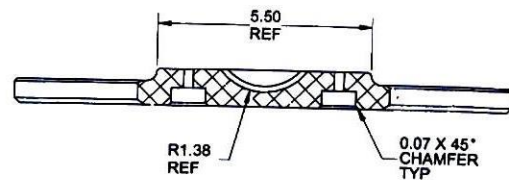
APPROVED



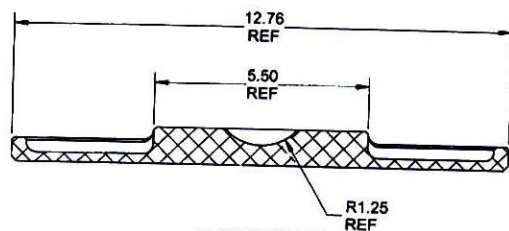
D4930-3 BEARPAW

RELEASED
2013-12-13
MB

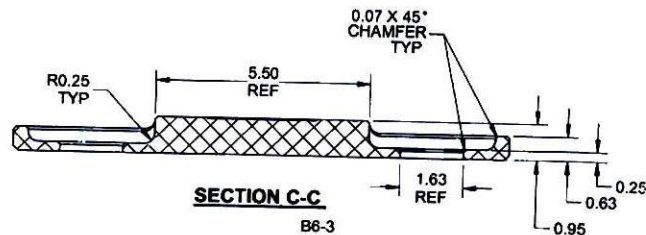
APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4930	SHEET 2 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BEARPAW	NTS
DATE		13.12.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



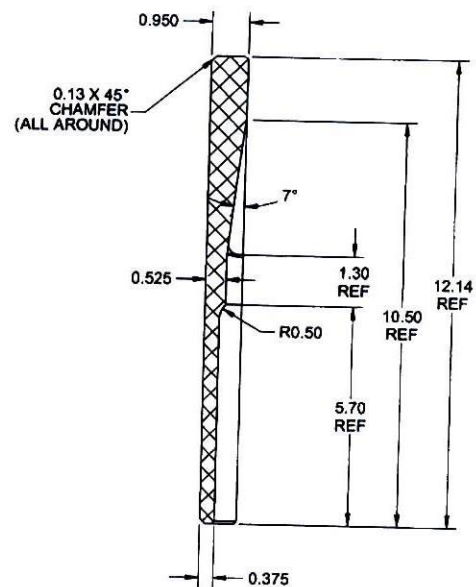
SECTION A-A
B6-3



SECTION B-B
C6-3



SECTION C-C
B6-3

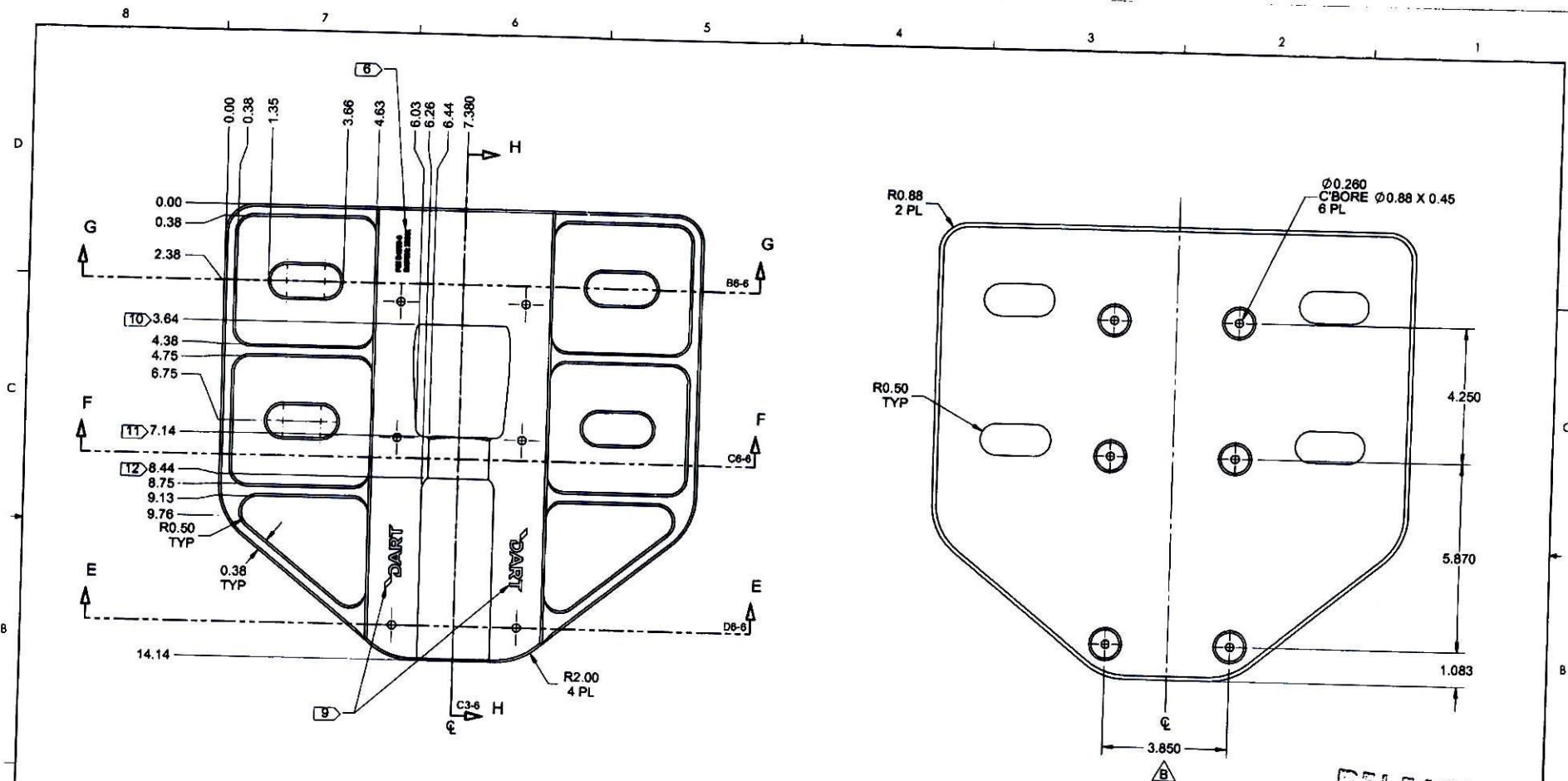


SECTION D-D
C6-3

D4930-1 BEARPAW

RELEASED
2013-12-12

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4930	SHEET 4 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BEARPAW	NTS
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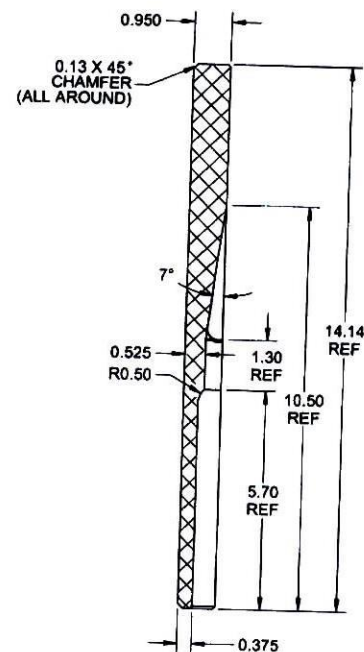
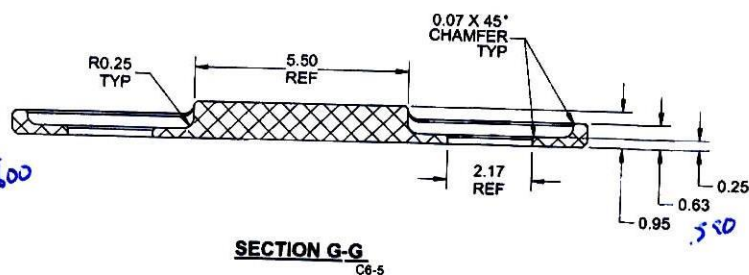
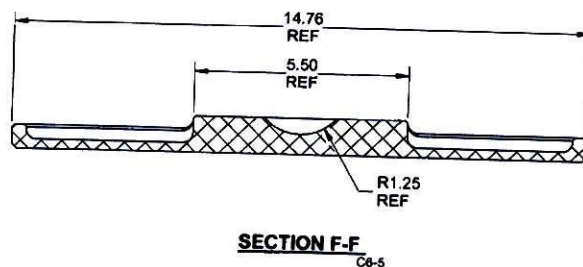
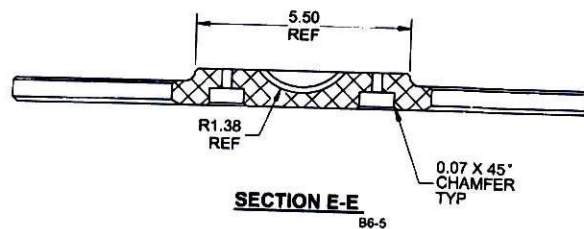
NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMBW10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010-0.012 DP WITH
A MINIMUM 0.010 RAD
- 7) WEIGHT: 3.39 lbs
- 8) PART IS SYMMETRIC ABOUT C
- 9) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A
MINIMUM 0.010 RAD
- 10) UNIFORM TAPER
- 11) MACHINE R1.25 BORE
- 12) MACHINE R1.38 BORE

D4930-3 BEARPAW

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4930	SHEET 5 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BEARPAW	NTS
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RELEASED
2013-12-12
WFO



D4930-3 BEARPAW

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
	DRAWN	VS		
	CHECKED	HS	DRAWING NO. D4930	SHEET 8 OF 8
	MFG. APPR.	JLM	TITLE	
	APPROVED	HS	BEARPAW	SCALE
	DE APPR.	DS	DATE 13.12.10	NTS

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